Work Order ID 68950

Tuesday, April 26, 2011 10:43:34 AM

Item ID: D3670-4-200 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: SPACER

Start Date: 4/26/2011 **Start Qty:** 60.00 **Cust Item ID:**

Required Date: 5/2/2011 **Req'd Qty:** 60.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** 11-04-26 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3670	Rev A ~~Rev B~~								
100	Hardinge CNC LATHE SMALL	0.00				61	∅		
Hardinge	**Memo**	0.00							
Hardinge CNC Lathe Small	1-TURN AS PER FOLIO FA711& DWG D3670□FOLIO REV: A DWG REV: A 2-DEBURR AS REQUIRED	11/5/11							
110	QC2- Inspect parts off machine FAI/FAIB	0.00				61	∅		
QC	**Memo**	0.00							
Quality Control		11/5/11							
120	QC8- Inspect parts - second check	0.00				61	∅		
QC	**Memo**	0.00	B.A 11/05/11						
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68950

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Run Start

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Stop

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location LC4	0.00				11/5/11	SP	60	
Packaging	**Memo**	0.00							
Packaging	***STOCK IN SKIDTUBE CELL***								
140	QC21- Final Inspection - Work Order Release	0.00					11/5/12		
QC	**Memo**	0.00							
Quality Control									

MF
11-05-12

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

Tuesday, April 26, 2011 10:43:40 AM

Work Order ID: 68950

Parent Item: D3670-4-200

Parent Item Name: SPACER

Start Date: 4/26/2011 **Required Date:** 5/2/2011

Start Qty: 60.00 **Required Qty:** 60.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.3125W.058		Purchased	No				f	191.6390		21.61081			
ALUM TUBE .3125 x .058w													

Location	Loc Qty	Loc Code
MAT013	191.639	
116793	1.667	
116939	93.972	
117400	96	

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	68950
Description: Spacer	**Part Number:**	**D3670-4200**
Inspection Dwg: D3670 **Rev:** A		**Page 1 of 1**

FIRST ARTICLE INSPECTION CHECKLIST

[X] **First Article** [ ] **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.313	+/-0.010	Ø.310	/		SA-9	
Ø0.197	+/-0.010	Ø.198	/			
4.200	+/-0.010	4.195	/			
0.060	+/-0.010	.060	/			
R0.03	+/-0.030	R.031	/			
0.015	+/-0.010	.012	/			

Measured by:	SD	Audited by:	B.A	Prototype Approval:	N/A
Date:	11/5/11	Date:	11/05/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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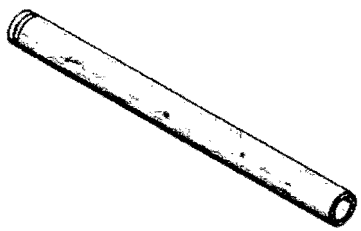
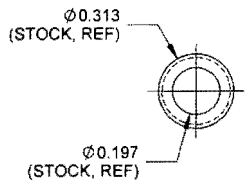
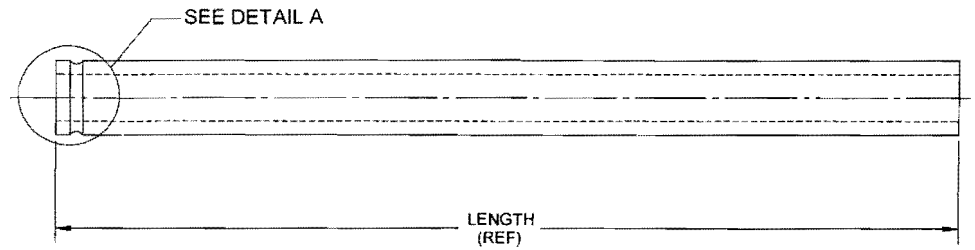
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

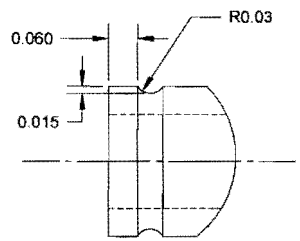
NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING









DETAIL A
(SCALE 4 : 1)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68950-
11-05-

SPECIFICATION: D3670-XXXX SPACER
LENGTH

WHERE XXXX IS LENGTH IN INCHES
EG: 3.750" LONG SPACER: D3670-3750

RELEASED
07.11.06

NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T0.313W.058)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: N/A

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	DC	07.10.19

DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED		DRAWING NO. D3670	REV. A SHEET 1 OF 1
MFG. APPR.			
APPROVED		TITLE SPACER	SCALE 2:1
DE APPR.			
DATE	07.10.19		

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Dart Aerospace Ltd

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